

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

1-11. (cancelled)

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12. (currently amended) A method for manufacturing a gusset bag having front and back surfaces composed of a pair of flat surfaces opposed to each other, and sides composed of pleat shaped side films connecting side edges of both flat surfaces and tucked in between said flat surfaces, the method comprising providing a pair of flat films moving in a longitudinal direction, inserting between said flat films said side films in a direction perpendicular to said longitudinal direction, bringing said flat films together and sealing said flat films to said side films, wherein said side films do not extend all the way across said flat films but terminate short of at least one longitudinal edge of said flat films, said side films having a square edge spaced from said at least one longitudinal edge, moving said flat films apart about a bend line disposed a distance from said squared end in a direction opposite said longitudinal edge, thereby to form a gore in said side film and tucking in said gore against said flat films, thereafter bringing said flat films together again and securing said flat films to each other beyond said gore.

13. (previously presented) A method as claimed in claim 12, and installing a zipper along said flat films parallel to but spaced from said longitudinal edge and between said longitudinal edge and said gore.

14. (previously presented) A method as claimed in claim 13, and sealing said longitudinal edges of said flat films together on a side of said zipper opposite said gore.

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15. (currently amended) A method for manufacturing a gusset bag having front and back surfaces composed of a pair of flat surfaces opposed to each other, and sides composed of pleat shaped side films connecting side edges of both flat surfaces and tucked in between said flat surfaces, the method comprising providing a pair of flat films moving in a longitudinal direction, inserting between said flat films said side films in a direction perpendicular to said longitudinal direction, bringing said flat films together and sealing said flat films to said side films, moving said flat films apart about bend lines disposed adjacent both ends of said side films, thereby to form gores in said side films and tucking in said gores against said flat films, thereafter bringing said flat films together again and securing said flat films to each other adjacent said gores, and severing said flat films and said side films in said longitudinal direction midlength of said side films.

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16. (currently amended) Apparatus for manufacturing a gusset bag having front and back surfaces composed of a pair of flat surfaces opposed to each other, and sides composed of pleat shaped side films connecting side edges of both flat surfaces and tucked in between said flat surfaces, comprising means for providing a pair of flat films moving in a longitudinal direction, means for inserting between said flat films said side films in a direction perpendicular to said longitudinal direction, means for bringing said flat films together and sealing said flat films to said side films, wherein said side films do not extend all the way across said flat films but terminate short of at least one longitudinal edge of said flat films, said side films having a square edge spaced from said at least one longitudinal edge, means for moving said flat films apart about a bend line disposed a distance from said squared end in a direction opposite said longitudinal edge, thereby to form a gore in said side film and tucking in said gore against said flat films, means for thereafter bringing said flat films together again and for securing said flat films to each other beyond said gore.

17. (previously presented) Apparatus as claimed in claim 16, and means for installing a zipper along said flat films parallel to but spaced from said longitudinal edge and between said longitudinal edge and said gore.

18. (previously presented) Apparatus as claimed in claim 16, and means for sealing said longitudinal edges of said flat films together on a side of said zipper opposite said gore.

73/ 19. (currently amended) Apparatus for manufacturing a gusset bag having front and back surfaces composed of a pair of flat surfaces opposed to each other, and sides composed of pleat shaped side films connecting side edges of both flat surfaces and tucked in between said flat surfaces, comprising means for providing a pair of flat films moving in a longitudinal direction, means for inserting between said flat films said side films in a direction perpendicular to said longitudinal direction, means for bringing said flat films together and for sealing said flat films to said side films, means for moving said flat films apart about bend lines disposed adjacent both ends of said side films, thereby to form gores in said side films and for tucking in said gores against said flat films, means for thereafter bringing said flat films together again and for securing said flat films to each other adjacent said gores, and means for severing said flat films and said side films in said longitudinal direction midlength of said side films.

20-25. (cancelled)

26. (new) A method of manufacturing a gusset bag having front and back surfaces composed of a pair of flat surfaces opposed to each other and sides composed of pleat-shaped side

surfaces connecting the side edges of the pair of flat surfaces connecting the side edges of the pair of flat surfaces and tucked in the pair of flat surfaces, comprising the steps of:

a. transferring a pair of flat films in such a manner that the flat films are opposed to each other in a vertical direction and form the front and back surface of the bag;

b. inserting side films between said pair of flat films so as to extend in a direction perpendicular to the transfer direction of said flat films and forming the side surfaces of said gusset bag, the side films each comprising a combination of V-shaped films opposed to each other;

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c. forming a strip-shaped film by placing the pair of flat films opposed to each other;

d. sealing the flat films and the side films;

e. forming an open surface at both ends of the side films and the flat films, forming an open surface made by tucking in each V-shaped side film at a gore crease from a point on the crease selected as a base point to an end of each V-shaped side film in a direction counter to the original crease and forming a convex edge in an inward direction of the gusset bag at a line connecting two corners at the ends of each V-shaped side film or the proximity thereof and said base point to thereby form an open surface at end of each of the side film and the flat film;

f. attaching, to each end of the flat films, a zipper tape or a V-shaped bottom film extending in a direction in parallel with the transfer direction of the flat films;

g. sealing together the zipper tape and/or V-shaped bottom film, the side films and the flat films; and

h. cutting the strip-shaped film along a prescribed cutting line located between at least two gusset bags to form the side films as side surfaces of two gusset bags located adjacent each other in front and back in the transfer direction of the strip-shaped film so as to form gusset bags in two rows to the left and right of the prescribed line.

27. (new) A method of manufacturing a gusset bag according to claim 26, wherein at least one end of each side film does not extend to the longitudinal edges of the flat films, said at least one end of each side film is square, and the step of sealing together the zipper tape and/or V-shaped bottom film and the flat films includes sealing the flat films along the longitudinal edges thereof.

28. (new) A method of manufacturing a gusset bag according to claim 26, further comprising the steps of: cutting a material at a center thereof into two halves; and separating the two halves into the pair of upper and lower flat films comprising said pair of flat surfaces before execution of the transferring step (a).

29. (new) A method of manufacturing a gusset bag having front and back surfaces composed of a pair of flat surfaces opposed to each other and sides composed of pleat-shaped side surfaces connecting the side edges of the pair of flat surfaces connecting the side edges of the pair of flat surfaces and tucked in the pair of flat surfaces, comprising the steps of:

a. transferring a pair of flat films in such a manner that the flat films are opposed to each other in a vertical direction and form the front and back surface of the bag;

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b. inserting side films between said pair of flat films so as to extend in a direction perpendicular to the transfer direction of said flat films and forming the side surfaces of said gusset bag, the side films being formed before the step of insertion from a pair of boat-shaped films opposed to each other, the boat-shaped films being prepared by folding a rectangular film at a center line, forming a bottom crease, tucking in the film at the crease from a point on the crease selected as a base point to an end of the film in a direction counter to the bottom crease, and tucking in said film at lines connecting two corners at the ends of the film or the proximity thereof and the base point in an inward direction of the gusset bag form a convex edge;

c. forming a strip-shaped film by placing the pair of flat films opposed to each other;

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- d. sealing the flat films and the side films;
 - e. forming an open surface at both ends of the side films and the flat films;
 - f. attaching, to each end of the flat films, a zipper tape or a V-shaped bottom film extending in a direction in parallel with the transfer direction of the flat films;
 - g. sealing together the zipper tape and/or V-shaped bottom film, the side films and the flat films; and
 - h. cutting the strip-shaped film along a prescribed cutting line located between at least two gusset bags to form the side films as side surfaces of two gusset bags located adjacent each other in front and back in the transfer direction of the flat films, and cutting the strip-shaped film along a prescribed line parallel with the transfer direction of the strip-shaped film so as to form gusset bags in two rows to the left and right of the prescribed line.

30. (new) A method of manufacturing a gusset bag according to claim 29, further comprising the steps of: cutting a material at a center thereof into two halves; and separating the two halves into the pair of upper and lower flat films comprising said pair of flat surfaces before execution of the transferring step (a).
